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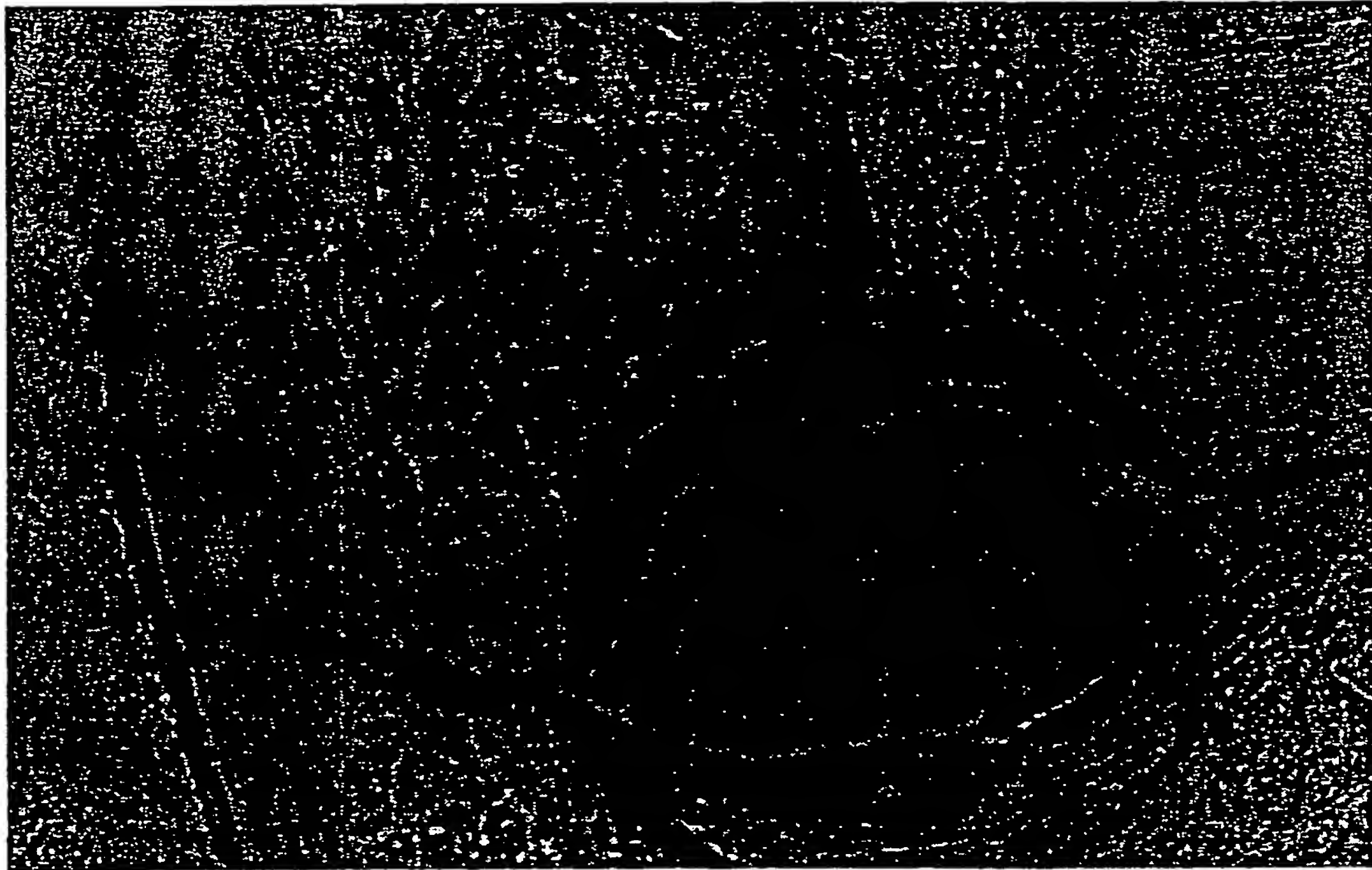
1/17											
Sample code	4/10/10	400	10	approximate spacing between perforations in machine direction (mm)	20	spacing between perforations in transverse direction (mm)	10 000	3	power (%)	0.55	4000
average perforation diameter (μm)	400	10	approximate spacing between perforations in machine direction (mm)	20	spacing between perforations in transverse direction (mm)	10 000	3	power (%)	0.55	4000	galvo speed (mm/s)
start positioning	x-4; y-160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	wpal
wpal	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	gpal
gpal	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	x=-4; y=160	x=4; Y=160	delay1
delay1	1	30	120	150	1	30	120	150	1	30	120
wpal2	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	gpal2
gpal2	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	x=-4; y=-160	x=4; y=-160	delay2
delay2	1	30	120	150	1	30	120	150	1	30	150

Figure 1

Sample code	Air pockets after stuffing	Surface craters after cooking	Removal of the net	Additional remarks
Standard	partially palm sized air pockets	essentially all hams show surface craters with diameters of up to 10 cm	o.k.	
8/20/20	15 % of the hams show air pockets with diameters ranging from 1cm to 4 cm	10 % of the hams show surface craters, 6 % require downgrading	o.k.	essentially all hams show pronounced surface nipples
6/10/10	2 % of the hams show small air pockets	essentially no surface craters which would require downgrading	o.k.	minor surface nipples, difficult to detect visually
4/10/10	5 % of the hams show small air pockets	3 % of the hams show surface craters; about 1-2 % require downgrading (border-line cases)	o.k.	practically no surface nipples
2/10/10	15 % of the hams show big air pockets	12 % of the hams show surface craters, 8 % require downgrading	o.k.	no surface nipples

Figure 2

Figure 3



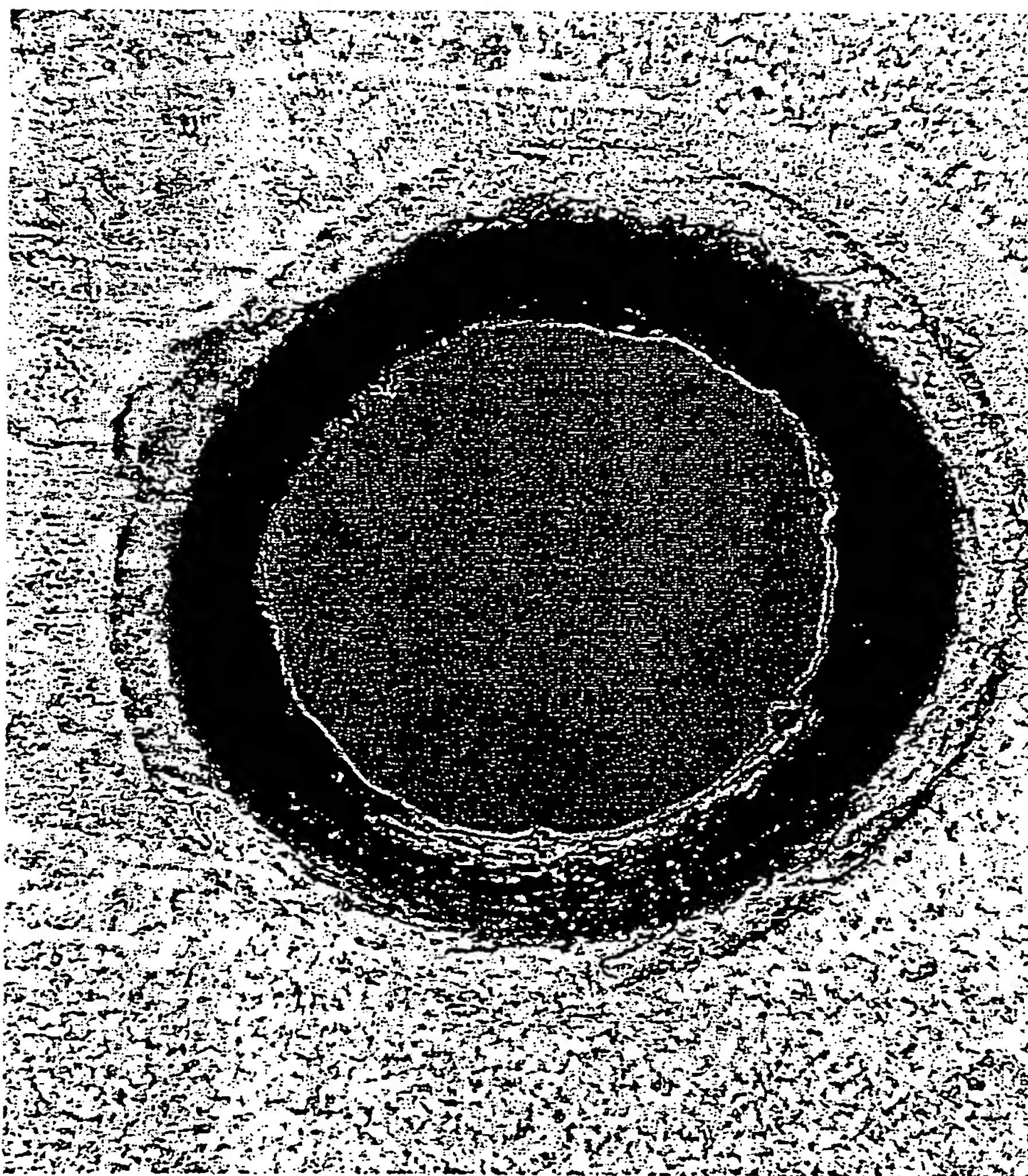


Figure 4

Figure 5

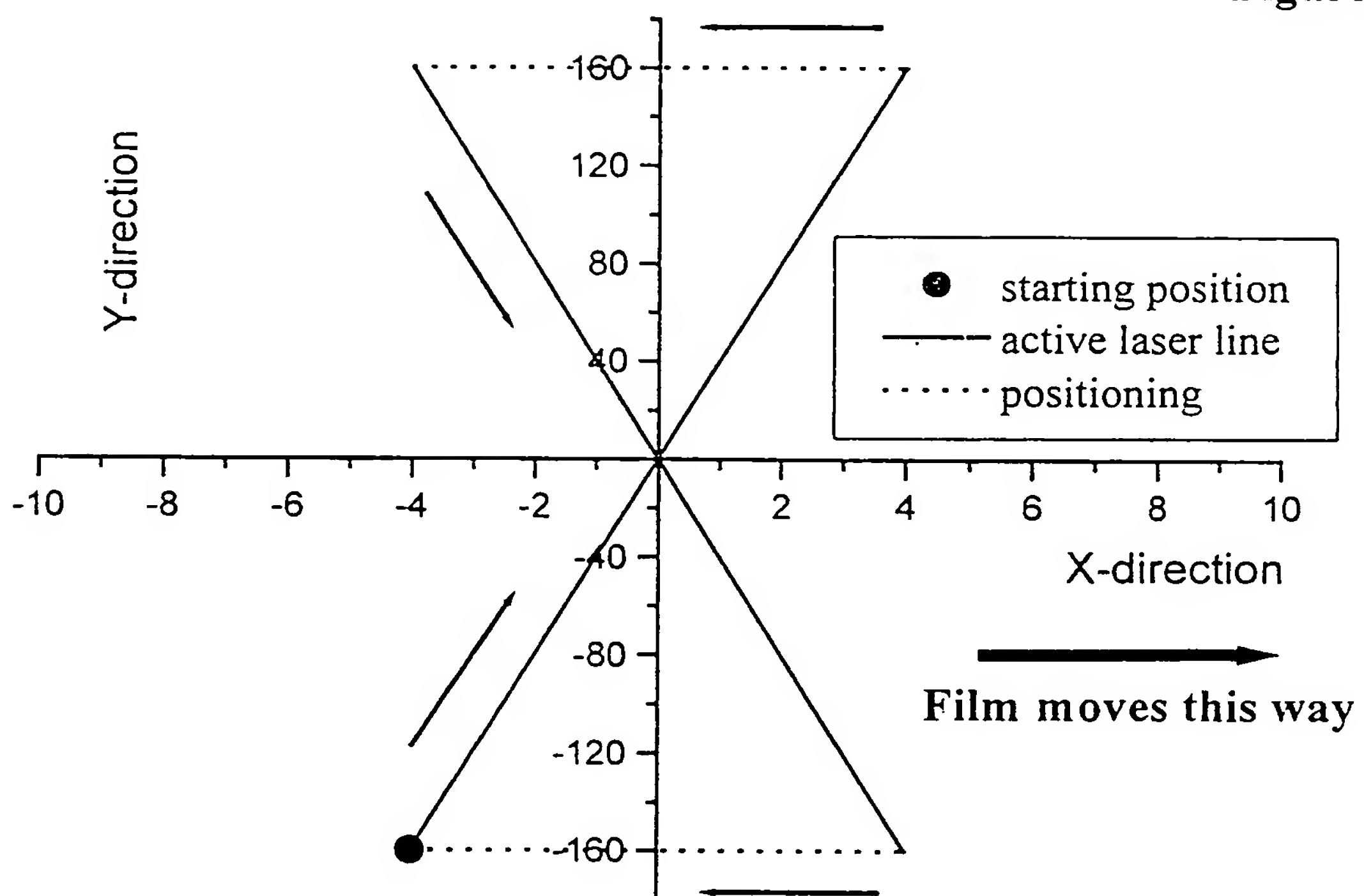


Figure 6

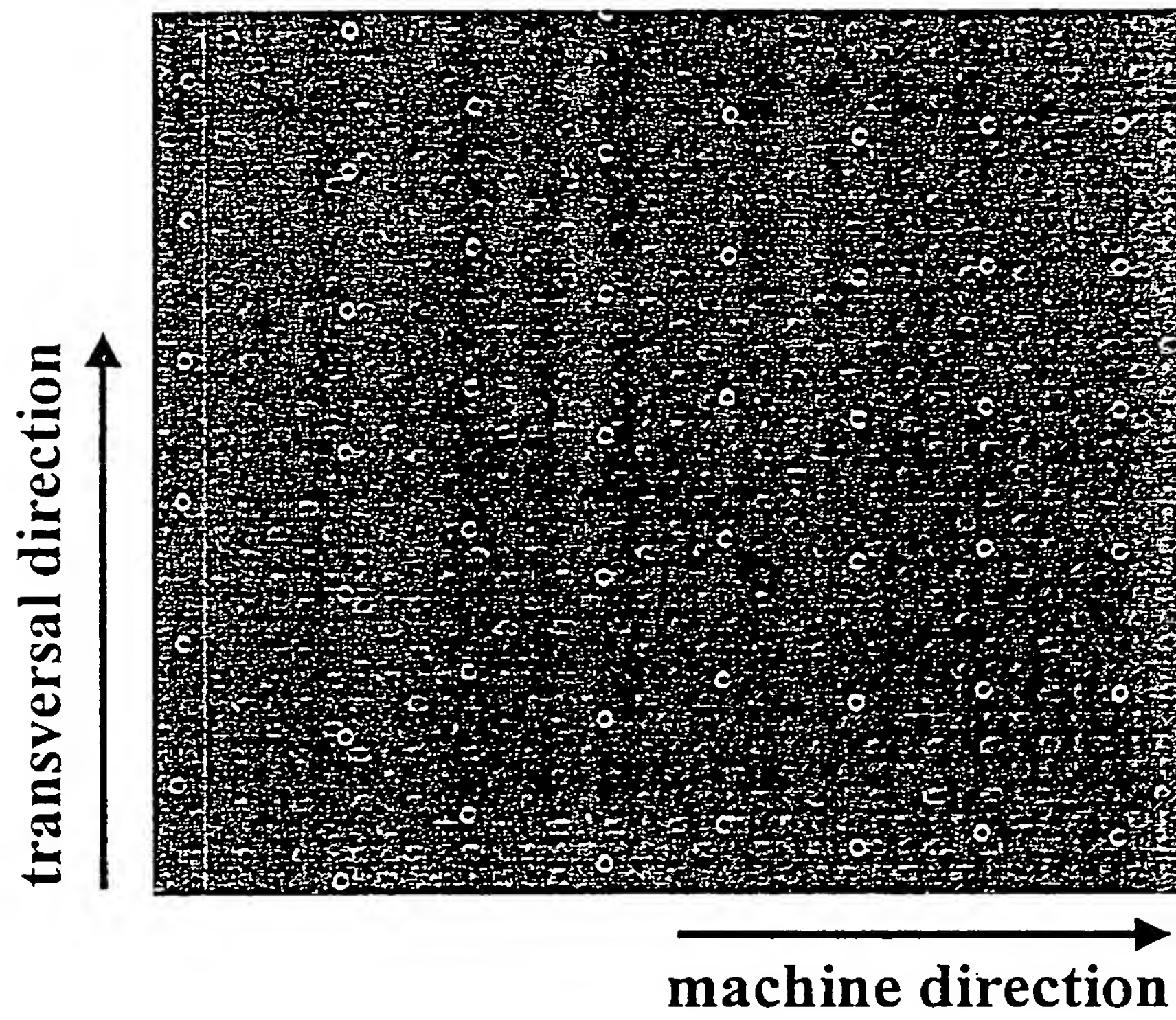


Figure 7

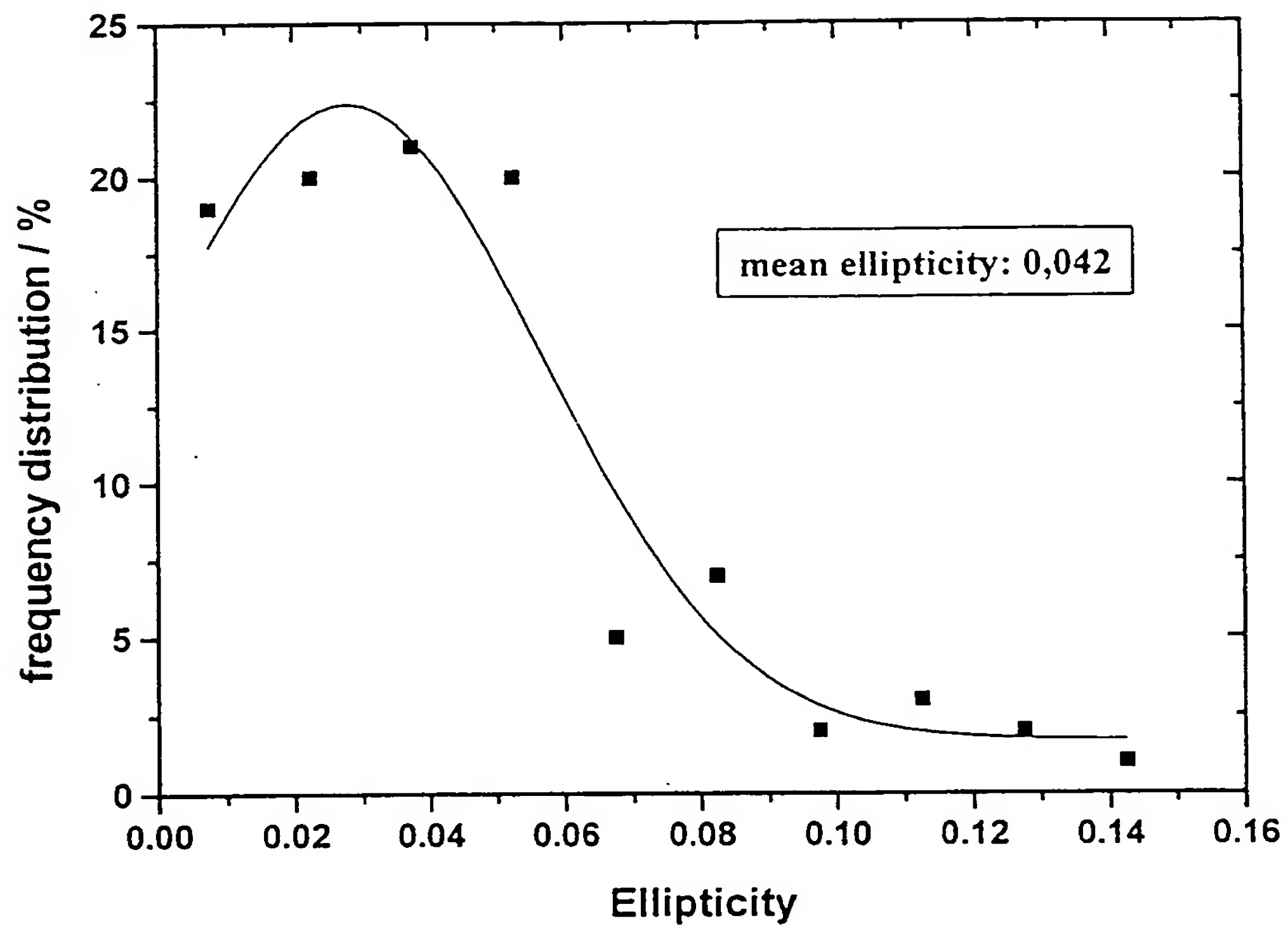


Figure 8

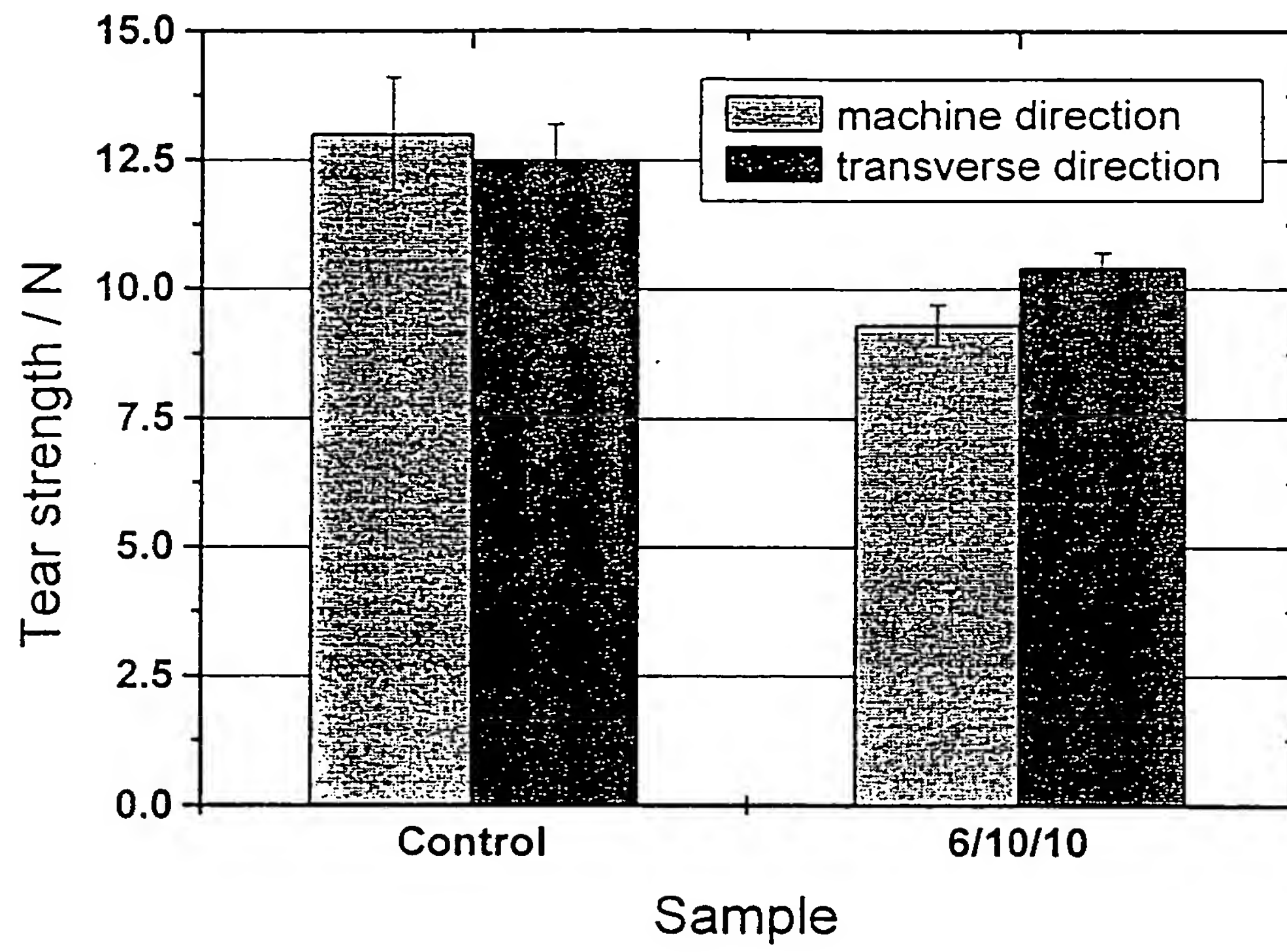


Figure 9

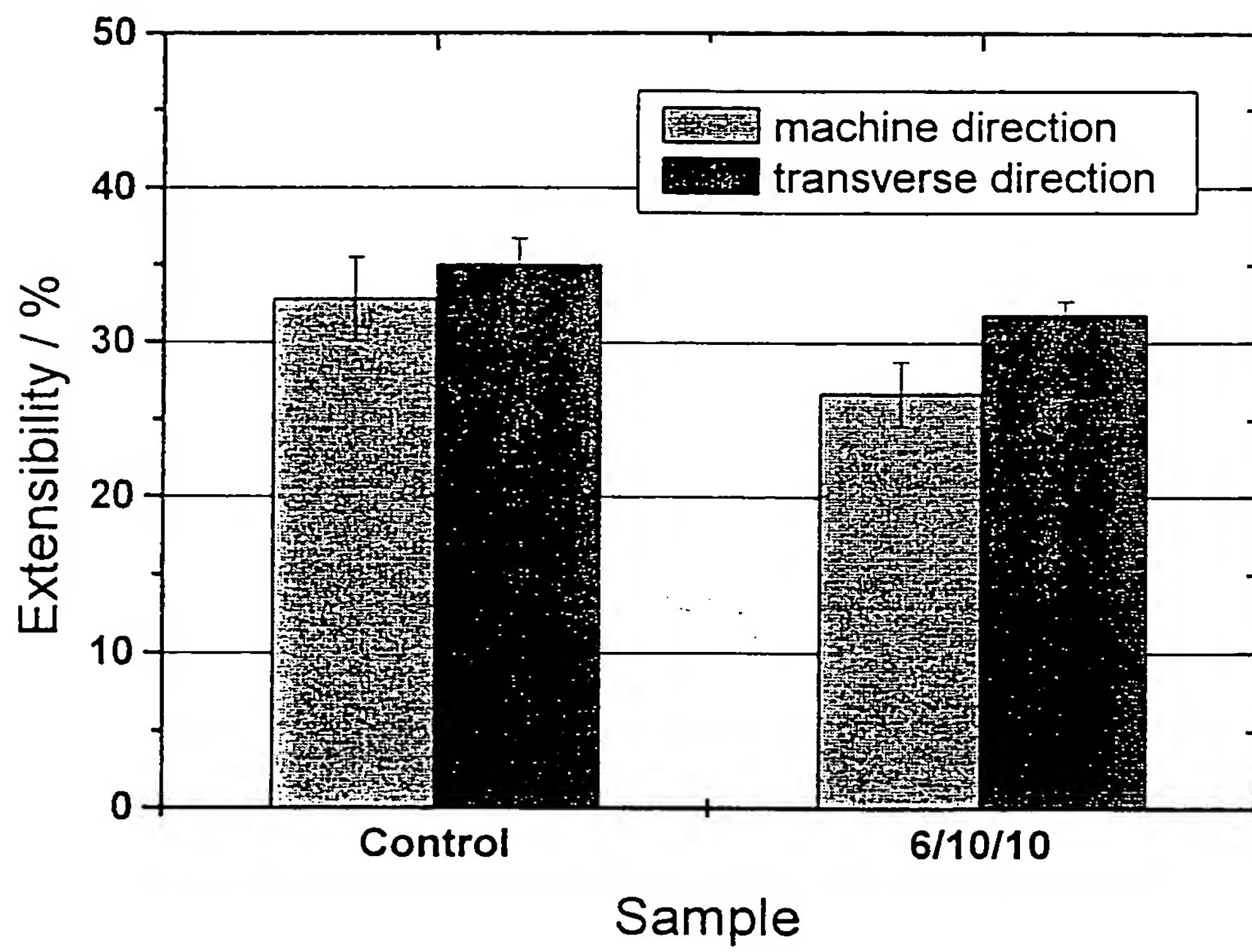
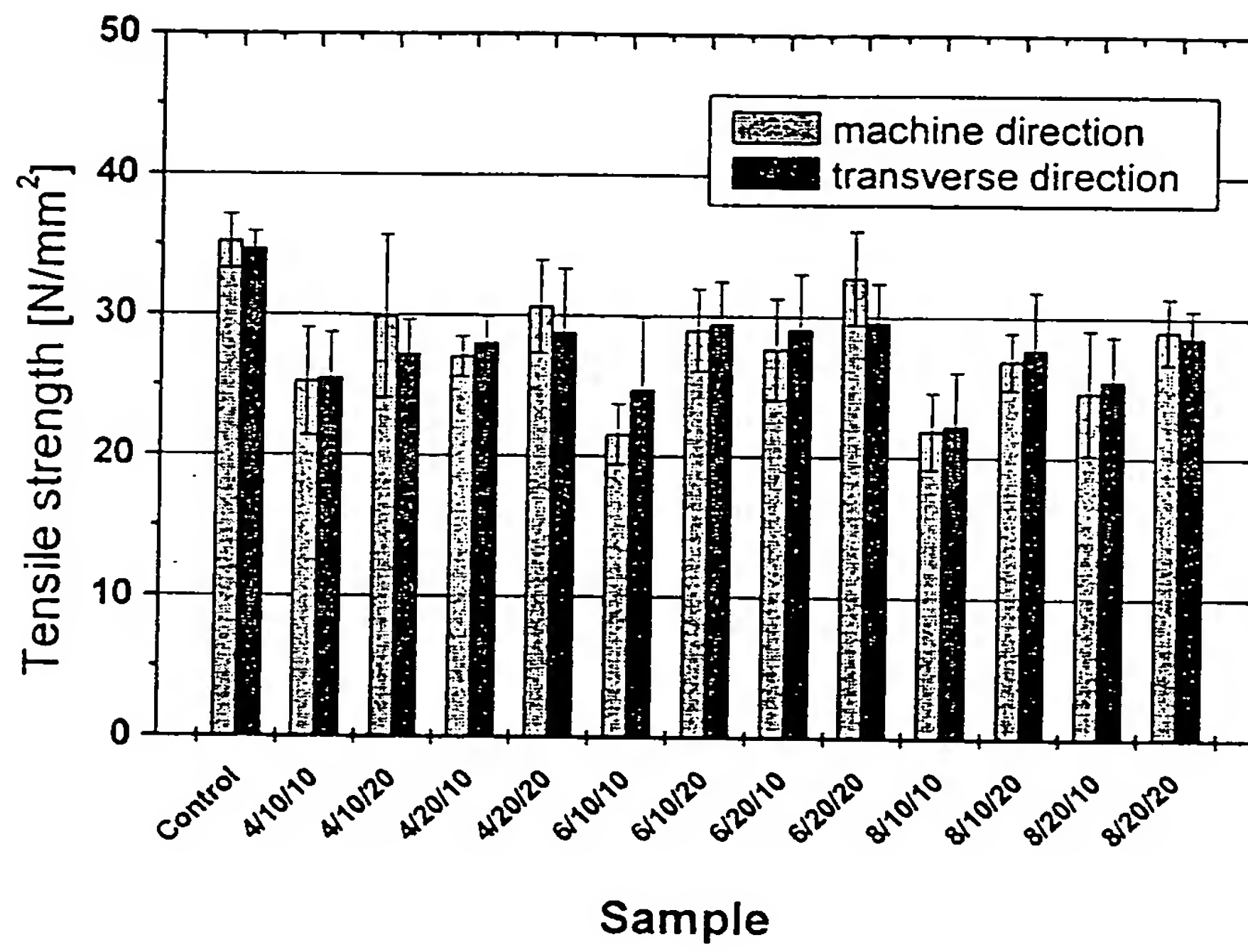


Figure 10



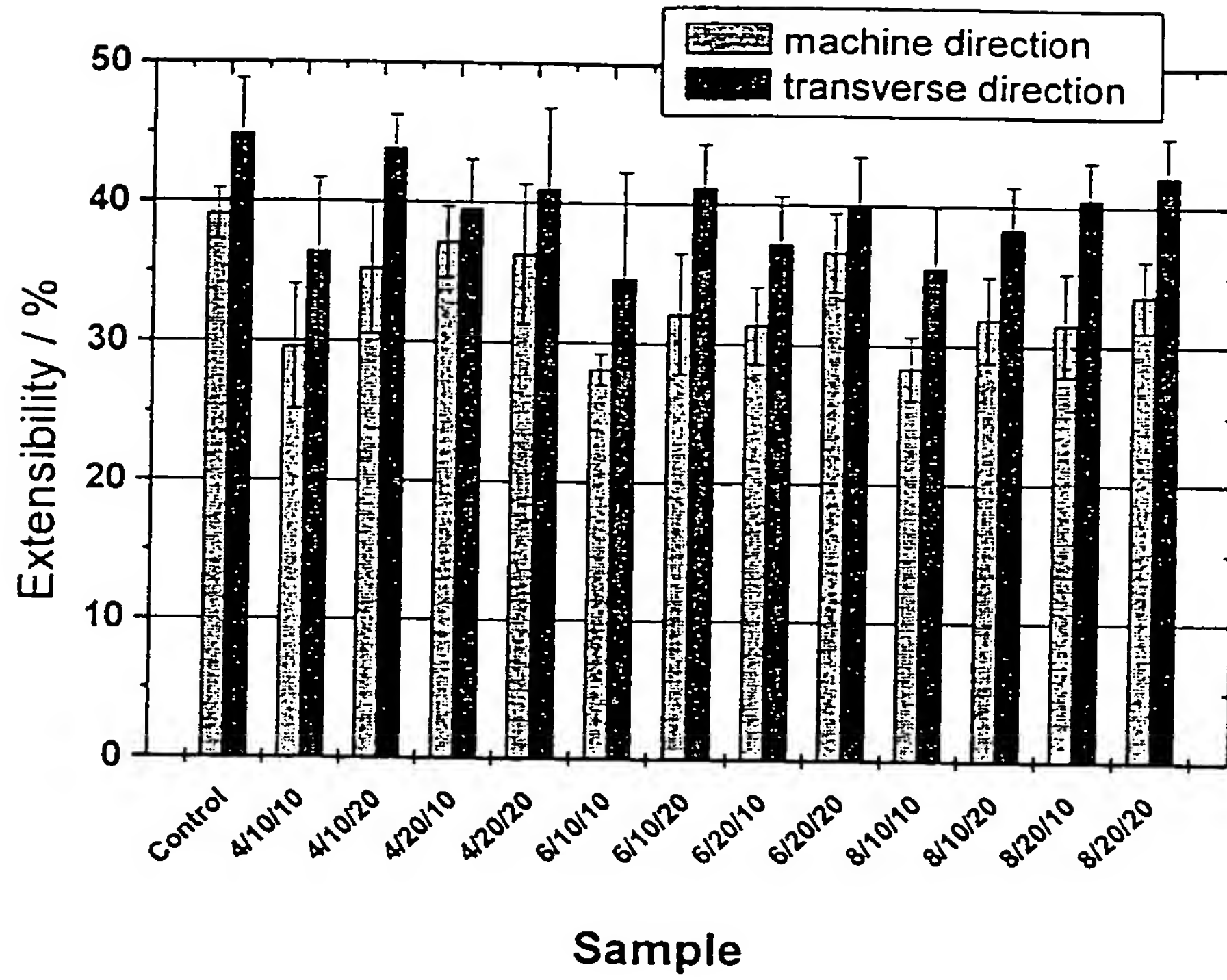


Figure 11

Figure 12

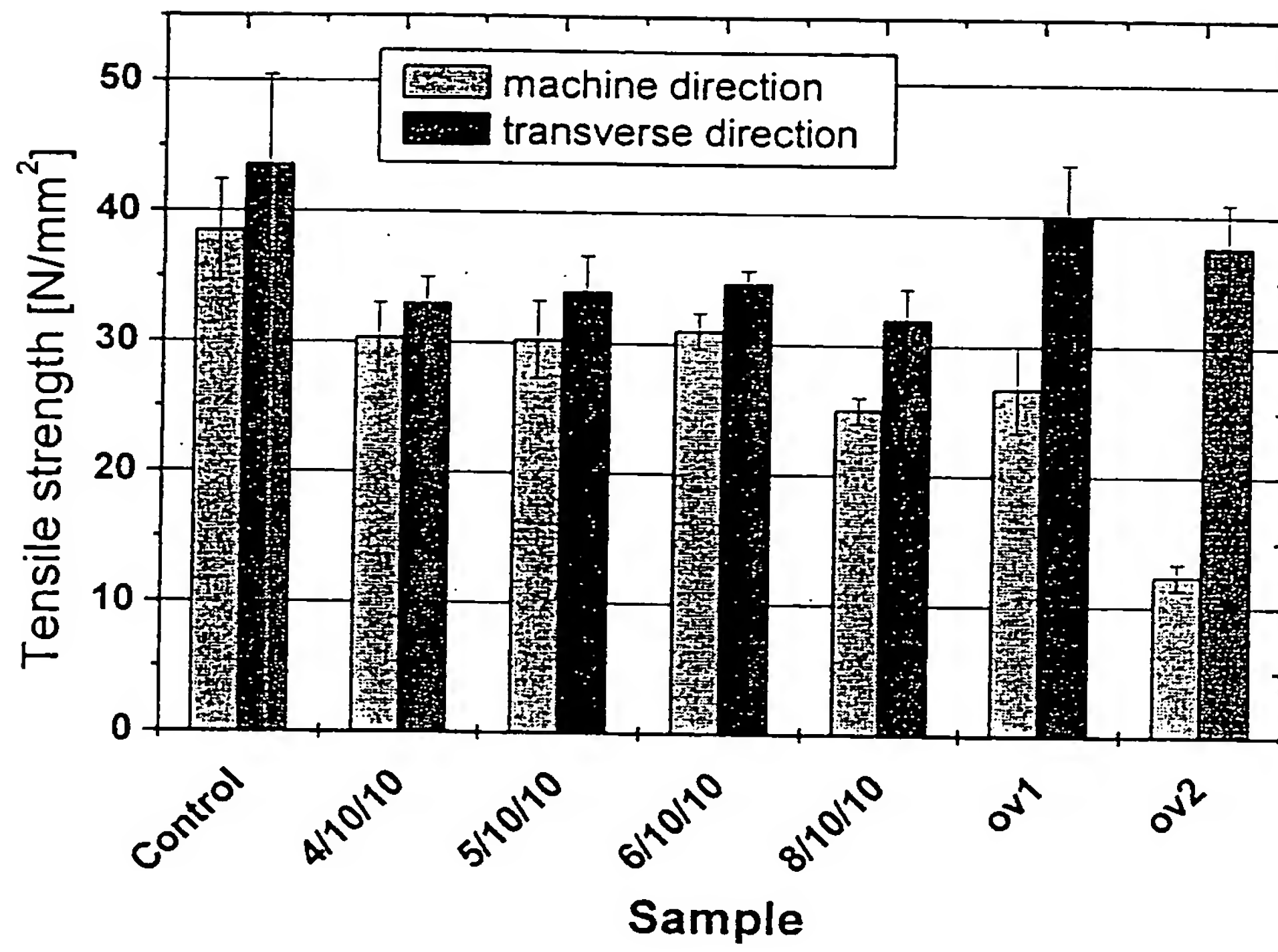


Figure 13

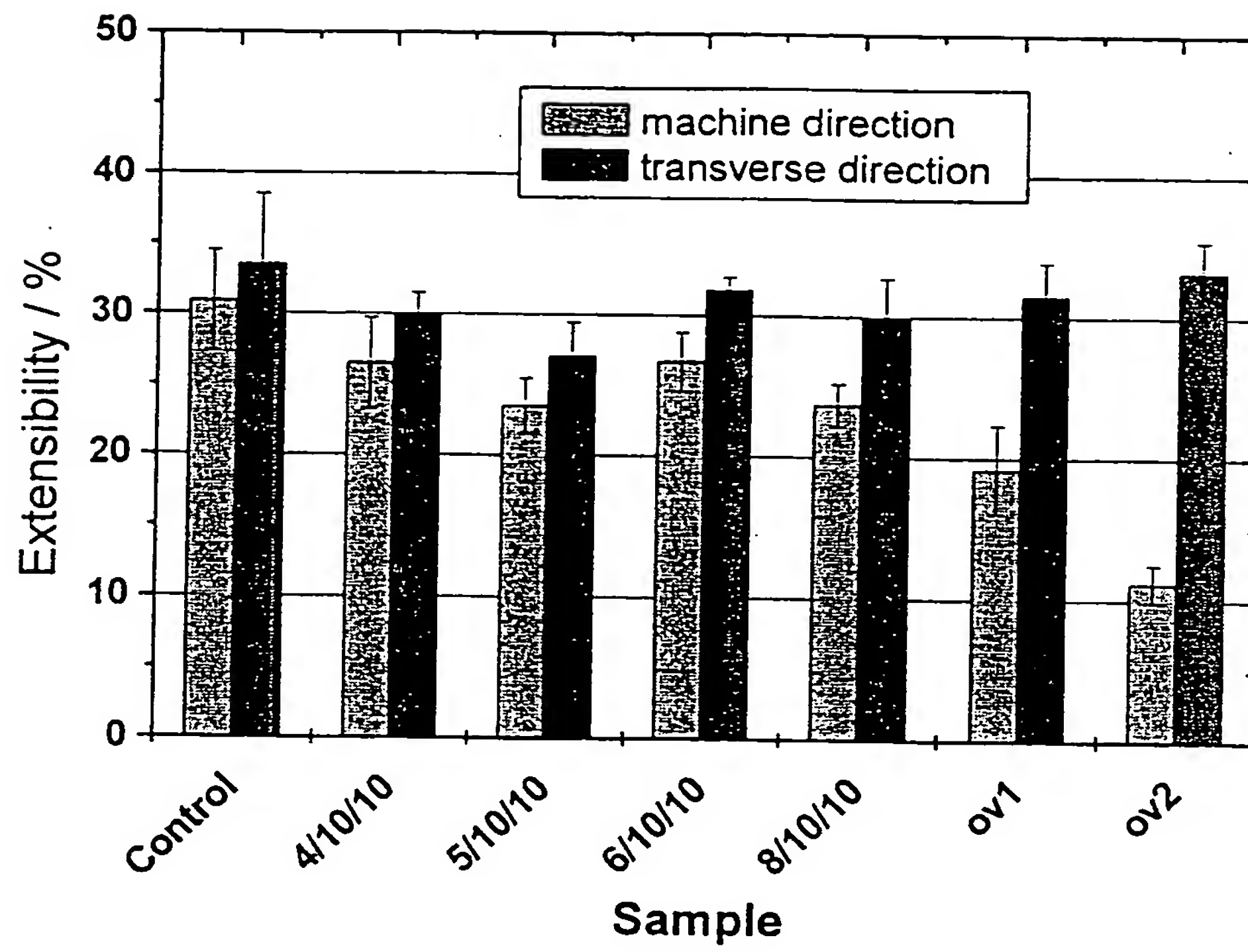


Figure 14

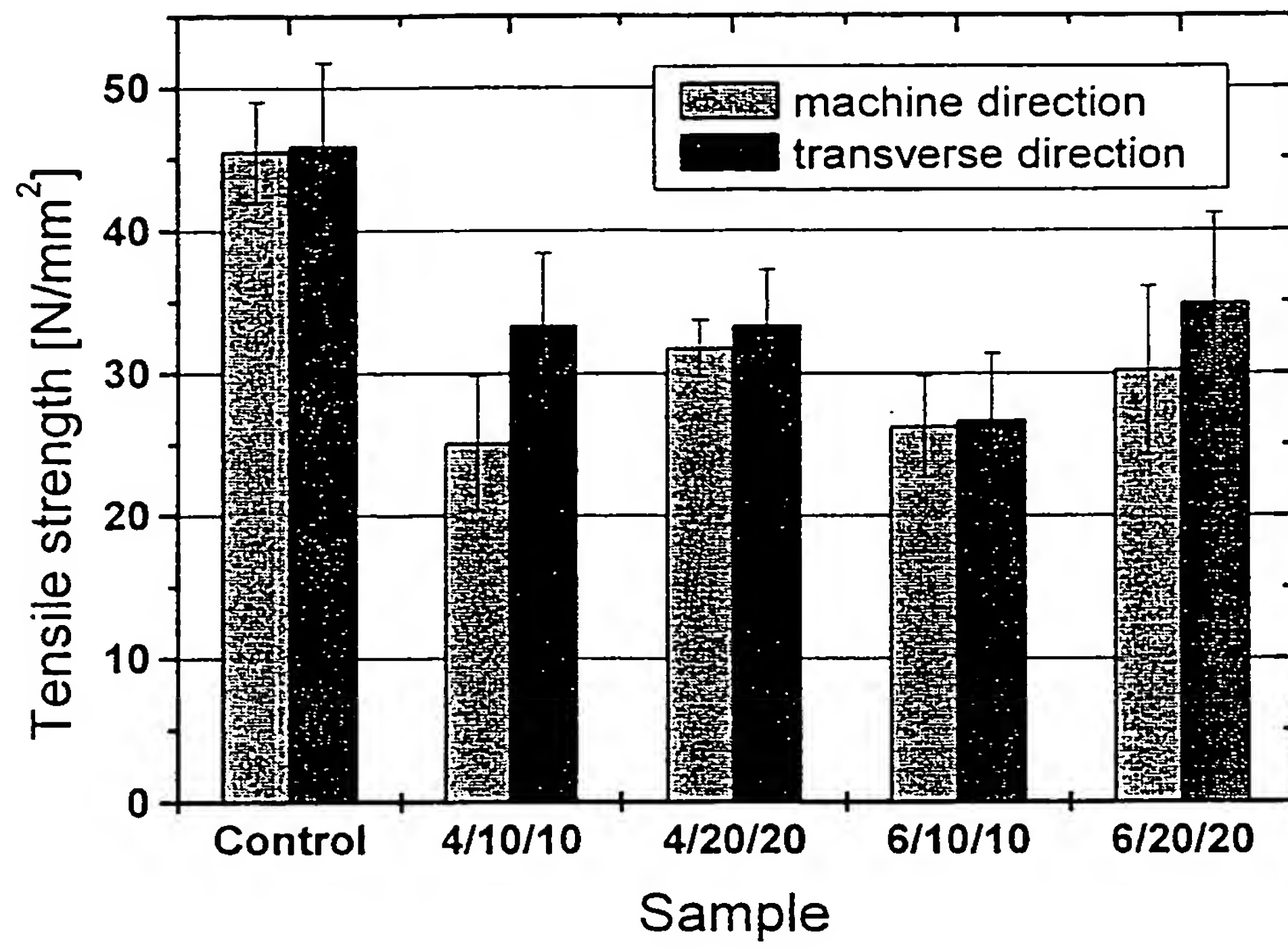


Figure 15

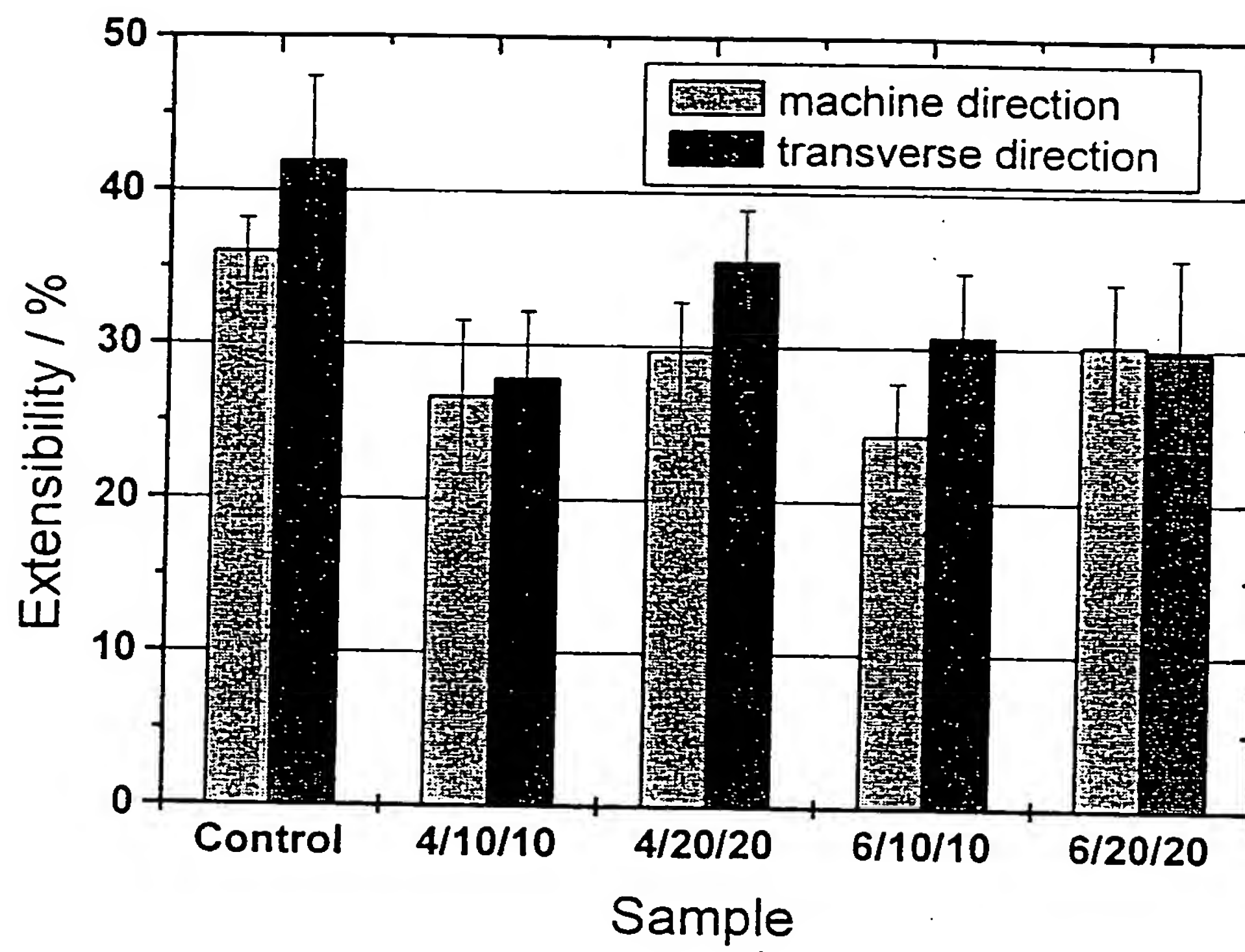


Figure 16

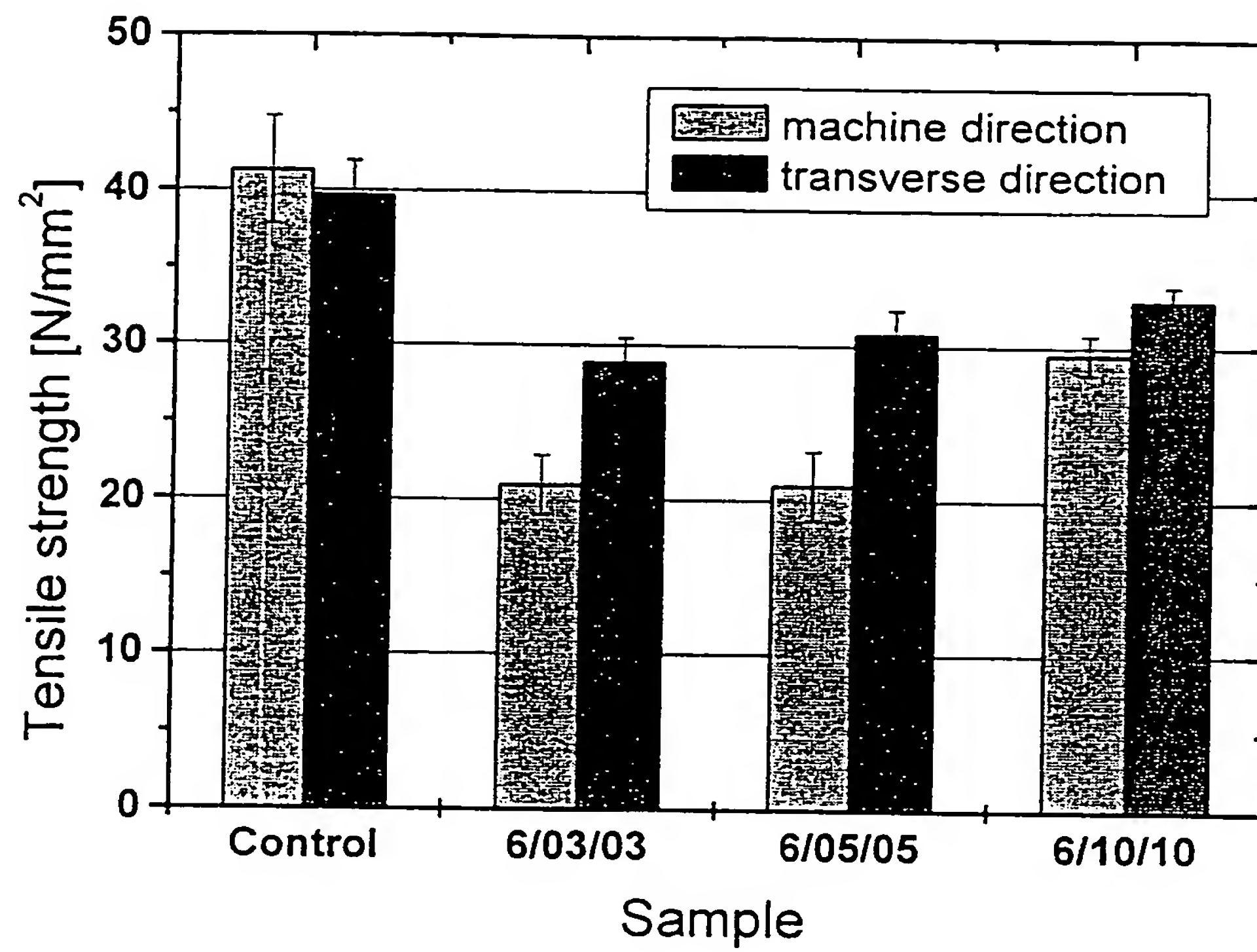


Figure 17

